

Work Order ID 61712

Tuesday, August 31, 2010 1:53:55 PM



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 8/31/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessaryB 10-9-1

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-9-1

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

JH-03
A 127226 100%

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: FP-10

0.00

= 2.52 10/09/03

26

0

Memo

0.00

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/02

mf 10-9-02

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Picklist Print

Tuesday, August 31, 2010 1:53:59 PM

Page 1

Work Order ID: 61712

Parent Item: D3794-3

Parent Item Name: Gasket



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	611.2133	1.2828	16.20379	334		
NEOPRENE SHEET 0.063											1810-9-1		

Location

Loc Qty

Loc Code

MAT

505.9602

114691

105.9602

115500

400

MAT052

105.2531

114176

105.2531

115500

26

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DART AEROSPACE LTD		Work Order:	61712
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.192	X		V	
0.300 x 0.300	+/-0.010	305 X 303	X		V	
1.88	+/-0.030	1.888	X		V	
4.281	+/-0.010	4.290	X		V	
6.44	+/-0.030	6.430	X		V	
6.00	+/-0.030	6.00	X		V	
6.75	+/-0.030	6.75	X		V	
2.00	+/-0.030	1.998	X		V	
4.75	+/-0.030	4.75	X		T	
9.50	+/-0.030	9.50	X		T	
14.25	+/-0.030	14.25	X		T	
17.75	+/-0.030	17.75	X		T	
26.74	+/-0.030	26.74	X		T	
29.23	+/-0.030	29.23	X		T	

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-9-1	Date: 10-9-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	[Signature]

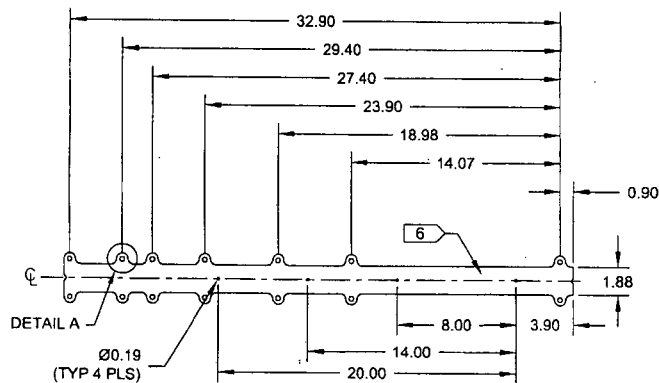
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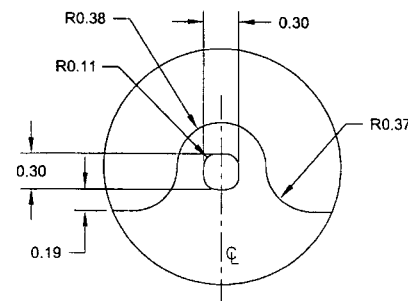
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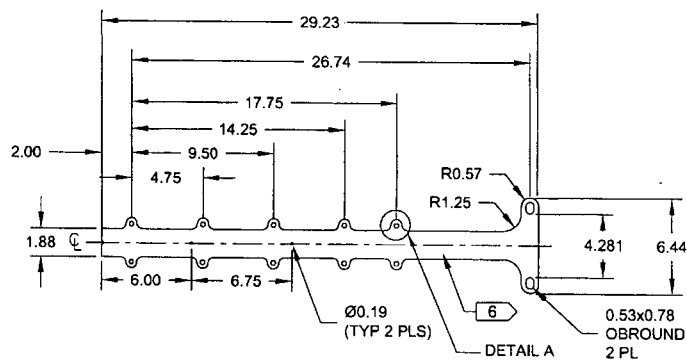
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHC 100
RETURNED
ENGINEER
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 41712

88-0-8-31

RELEASED
08-05-13/14

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	BY	DATE
DRAWN	PH			
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3794		SHEET 1 OF 1
APPROVED		TITLE		SCALE
DE APPR.		GASKET		NTS
DATE	08.05.14	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>		

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